



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3204-9
Job Sheet 173984



Part No: D3204-9

Job Qty: 12 ea

Part Name: Pedal



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 3/20/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		3/19/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	12 pcs		3/19/18	0.00	0.01	Bandsaw1		
110	CNC Vertical Machining	12 pcs		3/20/18	0.25	7.69	HAAS1-3		
130	QC	12 pcs		3/20/18	0.00	0.00	QC8 Machining-2		
140	Packaging	12 pcs		3/20/18	0.00	0.00	Packaging3-1		
150	QC21-SA	12 Ea		3/20/18	0.00	0.00	QC21		

Part Op 100 - Cut blank: 2.000" x 0.375" x 3.100" long Bar

Descriptions: 110 - 1- Machine as per Folio FA357 and Dwg D3204 Identify as D3204-9

140 - *****STOCK IN LARGE FAB*****

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X2.000	6061-T6 Bar .375 X 2.00	3.2256 ft (.2688 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X2.000	3	47	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermof ☐ Cross ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐																																																								
Date : _____ Step #: _____		Container No: S055732 Part: D3204-9 Job No: 173984 Serial No/Batch: S055732 Revision: _____ Inspector: _____ Date: 03/28/10																																																										
Description Work Order Deviation																																																												
		MRB (QSI042) Approval																																																										
		Completed By																																																										
		Lead hand / Supervisor Approval Verification																																																										
		QC / QA Coordinator Approval																																																										
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:15%;">☐</td> <td style="width:15%;">No Re-verification</td> <td style="width:15%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> <tr> <td colspan="2"></td> <td colspan="2"> OTHER : _____ </td> </tr> </tbody> </table>					Root Cause				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐			OTHER : _____	
Root Cause																																																												
Environment	☐	No Re-verification	☐																																																									
Design	☐	Operator	☐																																																									
Doc/Data	☐	Offset/Setup	☐																																																									
Equip/Tooling	☐	Supplier	☐																																																									
Handling/Pre	☐	Training	☐																																																									
Material	☐	Use for Testing	☐																																																									
Internal Transport	☐	Poor Information	☐																																																									
Tribal Knowledge	☐	Rushing	☐																																																									
LOA	☐	Product Improvement	☐																																																									
Substation	☐	Process Improvement	☐																																																									
Past Expiry Date	☐	Manufacturing Process	☐																																																									
Misidentified	☐	Past Due	☐																																																									
		OTHER : _____																																																										
		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Label ☐ Misread ☐ Turning Sequence ☐																																																										

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Pedal	0.500inches $\pm$ 0.030	0.530 0.470		
2	Pedal	0.250inches $\pm$ 0.010	0.260 0.240		
3	Pedal	0.080inches $\pm$ 0.010	0.090 0.070		
4	Pedal	0.110inches $\pm$ 0.010	0.120 0.100		
5	Pedal	45Degrees $\pm$ 0	45 45		
6	Pedal	0.620inches $\pm$ 0.010	0.630 0.610		
7	Pedal	3.000inches $\pm$ 0.010	3.010 2.990		
8	Pedal	2.000inches $\pm$ 0.030	2.030 1.970		
9	Pedal	0.310inches + 0.010 - 0.000	0.320 0.310		
10	Pedal	0.780inches $\pm$ 0.010	0.790 0.770		
11	Pedal	1.750inches $\pm$ 0.010	1.760 1.740		
12	Pedal	0.134inches + 0.005 - 0.000	0.139 0.134		

Plex 3/8/18 1:26 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

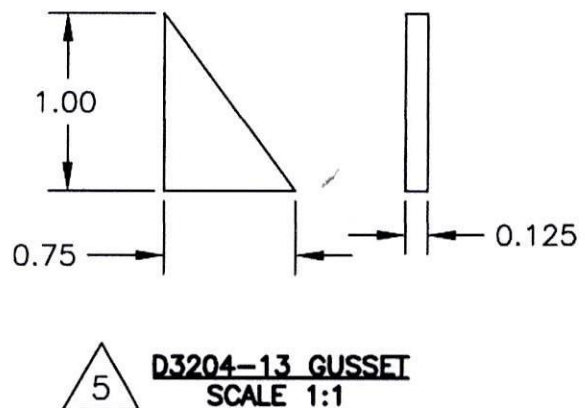
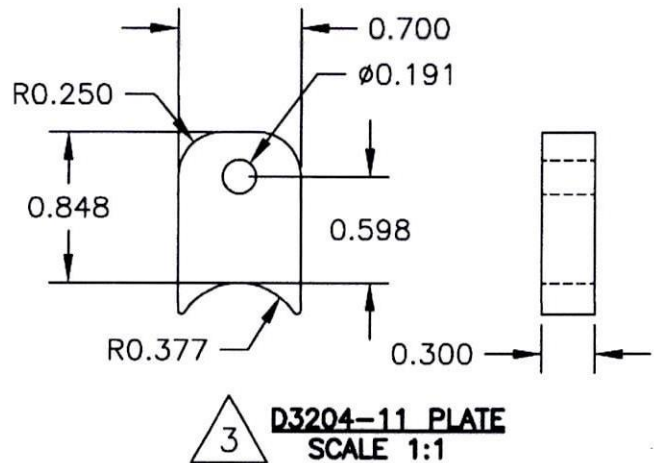
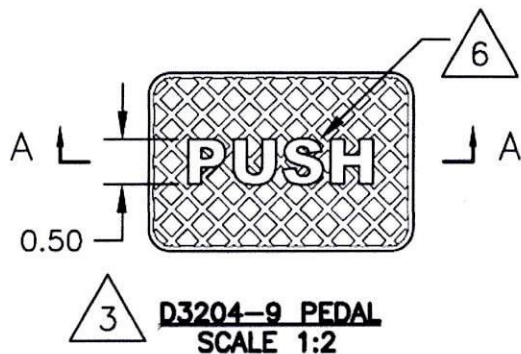
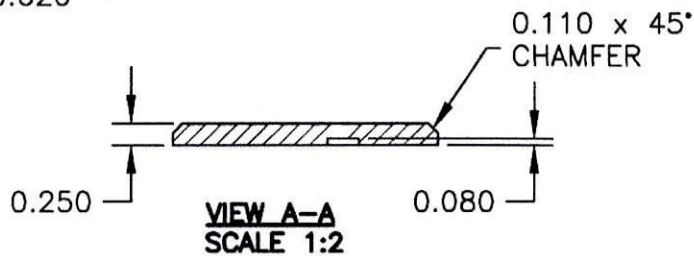
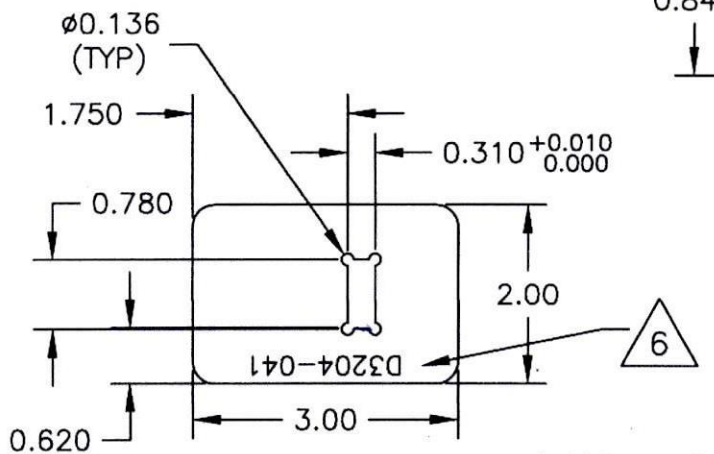
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

RELEASED
04.04.30



Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.